

Date: Wednesday, 08/04/2009 9:14:01 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 407 FWD X-TUBE, TURNING DETAIL
Job Number : 47077	
Estimate Number : 13204	
P.O. Number :	Part Number : D407667105TRN
This Issue : 08/04/2009 S.O. No. :	Drawing Number : D407-667-145 REVC
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : CROSSTUBES	Drawing Revision : C
Previous Run : 47076	Material :
Written By :	Due Date : 15/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09.04.08</u>	
Comment : Est Rev:a 08.02.28 new issue EC Est Rev B 08.04.02 Removed polish EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6010115	Crosstube Material
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D6010-115 Crosstube

Check OD = 2.250"; ID = 1.610"

B26424

a.m 09.04.16 ②

2.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand & install plugs DT8673 on both ends as per Folio FA249

2-Turn first side as per Folio FA249

3- File transition lines smooth.

a.m 09.04.16 ②

3.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

a.m 09.04.16 ②

4.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA249

2- File transition lines smooth.

3-Remove sand and plugs

a.m 09.04.16 ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 08/04/2009 9:14:01 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 FWD X-TUBE, TURNING DETAIL

Job Number: 47077

Part Number: D407667105TRN

Job Number:



Seq. #:

Machine Or Operation:

Description :

4-Scribe part # and batch # using vibrating stylus as per Dwg D206-667-145
Inside of Cuff (Do not engrave on outside of tube)

AWM 09-04-16 (1)

5.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

AWM 09-04-16 (1)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

AWM 9-4-16

(1)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 9-4-17

(1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/04/17 (1)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock in Kanban rack

Location:

X-TUBE CELL

AWM 9-4-17

(1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Doc 104/20

MF

09-04-17

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47077
Description: Crosstube Assembly		Part Number: D407-667-145
Inspection Dwg: D407-667-145 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.240	/			
	1.865	+0.005/-0.000	1.866	/			
	1.878	+0.005/-0.000	1.883	/			
	1.970	+0.005/-0.000	1.970	/			
	2.030	+0.005/-0.000	2.030	/			
	2.165	+0.005/-0.000	2.169	/			
	0.125	+/-0.010	0.125	/			
	R0.063	+/-0.010	R0.063	/			
	R0.500	+/-0.010	R0.500	/			
	R0.063	+/-0.010	R0.063	/			
	4.438	+/-0.010	4.438	/			
SIDE B	2.240	+0.005/-0.000	2.243	/			
	1.865	+0.005/-0.000	1.869	/			
	1.878	+0.005/-0.000	1.883	/			
	1.970	+0.005/-0.000	1.972	/			
	2.030	+0.005/-0.000	2.030	/			
	2.165	+0.005/-0.000	2.170	/			
	0.125	+/-0.010	0.125	/			
	R0.063	+/-0.010	R0.063	/			
	R0.500	+/-0.010	R0.500	/			
	R0.063	+/-0.010	R0.063	/			
	4.438	+/-0.010	4.438	/			
	113.20	+/-0.020	113.190	/			

Measured by: a.m.	Audited by: AWM	Prototype Approval: N/A
Date: 09.04.16	Date: 9-4-16	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.04.21	New Issue (P/O D407-667-105)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

Item	Qty -145	Part Number	Description
1	X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
2	1	D6010-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

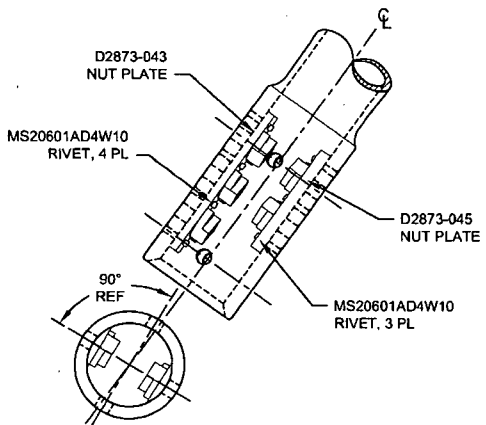
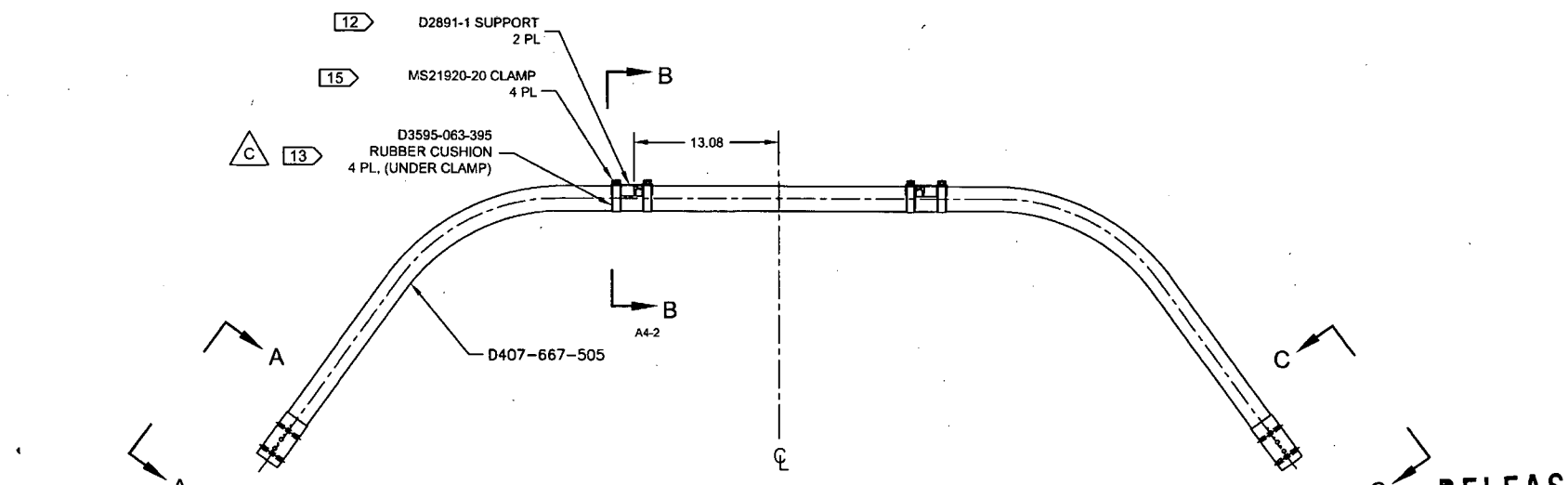
- 1) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D407-667-145" AND BATCH NUMBER ON
INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 17.8 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER
QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE
THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS
ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
08/11/06

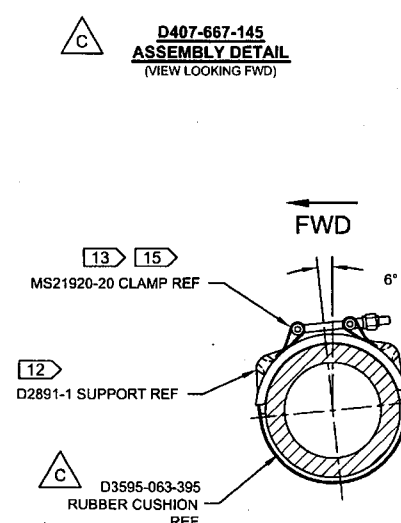
C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. 7 ADD TOLERANCES (ZN C6-3, C4-3, D2-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	02.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D407-667-145	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
DE APPR.	RF	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

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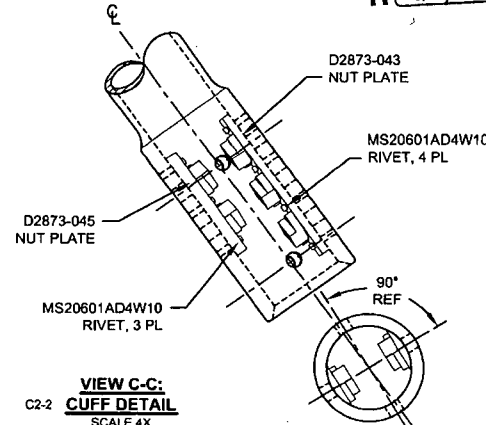
8 7 6 5 4 3 2 1



VIEW A-A:
CUFF DETAIL
SCALE 4X



SECTION B-B
SCALE 5X

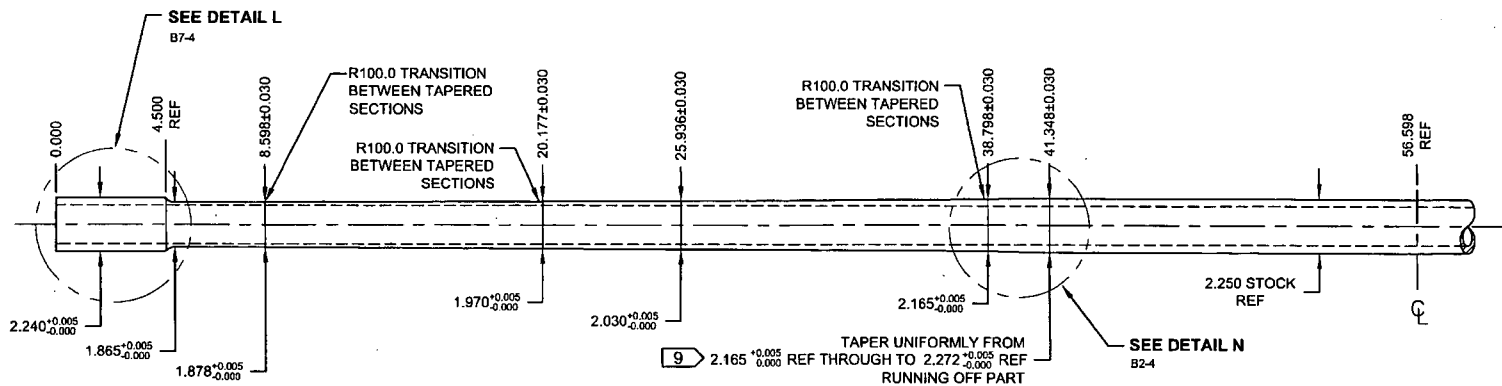


VIEW C-C:
CUFF DETAIL
SCALE 4X

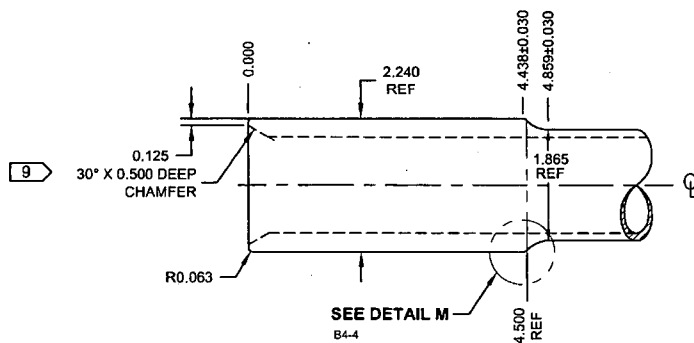
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08/11/06

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D407-667-145	SHEET 2 OF 4
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	CROSSTUBE ASS'Y (407 HIGH FWD)	NTS
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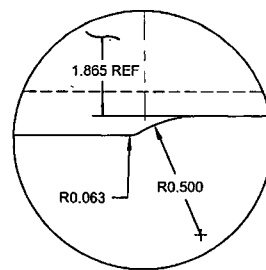
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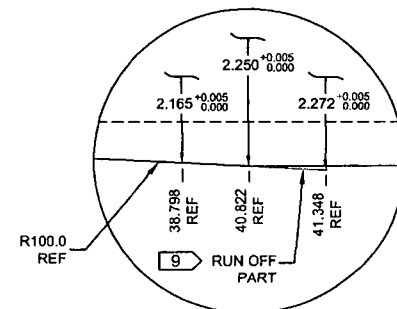
TURNING DETAIL



DETAIL L: CROSSTUBE CUFF
NOT TO SCALE



DETAIL M: CUFF TRANSITION
NOT TO SCALE



DETAIL N: TAPER RUN-OFF
NOT TO SCALE

RELEASED
CS/H/12/VW

DESIGN	9	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	UP	DRAWING NO. REV. C
MFG. APPR.	EF	D407-667-145 SHEET 4 OF 4
APPROVED	UP	TITLE SCALE
DE APPR.	UP	CROSSTUBE ASSY (407 HIGH FWD) NTS
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